

Date: Thursday, 10/25/2007 10:03:52 AM
 User: Kim Johnston

Process Sheet

44

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 BEARPAW
Job Number : 35348A	
Estimate Number : 10100	
P.O. Number :	Part Number : D30751
This Issue : 10/25/2007 S.O. No. :	Drawing Number : D3075 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 30791A	Material :
Written By :	Due Date : 11/2/2007 Qty: 20 Um: Each
Checked & Approved By : <u>07 10 25</u>	
Comment : Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM	
Est Rev: D Added C'Bores as per Rev B 07-03-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 1.8949 sf(s)/Unit Total : 37.8980 sf(s)

Pick:

blank: 10.50" x 13.00" x 1.00" thick (+0.030/-0.000) per DSK086-12

Material: Black UHMW 1"(MUHMWB10)

Batch: M106717

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1

3-Deburr

40

JL/DJP 08/01/30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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40

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/DJP 08/01/30

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

JL/DJP 08/01/30 40

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/01/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:03:52 AM
User: Kim Johnston

Process Sheet

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Drawing Name: R44 BEARPAW

Job Number: 35348A

Part Number: D30751

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 35754 C 8/21/301 @ 11:40 u

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

208101/31

Job Completion



u 08-01-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 35348A
Description: R44 Bearpaw		Part Number: D3075-1
Inspection Dwg: D3075	Rev: A2 B C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

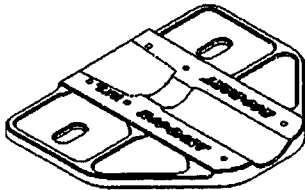
Inspection Sheet	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	.066x45°	✓			
B	0.63	+/-0.030	.620	✓			
C	0.250	+/-0.010	.243	✓			
D	0.950	+0.030/-0.010	.951	✓			
E	5.50	+/-0.030	5.50	✓			
F	0.25 x 45°	+/-0.030	.240x45°	✓			
G	0.900	+/-0.010	.892	✓			
H	0.375	+/-0.010	.374	✓			
I	1.30 ✓	+/-0.030	1.30	✓			
J	5.70 ✓	+/-0.030	5.695	✓			
K	0.37	+/-0.030	.376	✓			
L	3.600	+/-0.010	3.600	✓			
M	0.260	+0.005/-0.000	.260	✓			
N	0.93 ✓	+/-0.030	.930	✓			
O	0.30	+0.030/-0.000	.310	✓			
P	1.08	+/-0.030	1.080	✓			
Q	5.870	+/-0.010	5.870	✓			
R	10.14	+/-0.030	10.14	✓			

Measured by: J.L.	Audited by: JML	Prototype Approval: N/A
Date: 08/01/27	Date: 08/01/29	Date: N/A

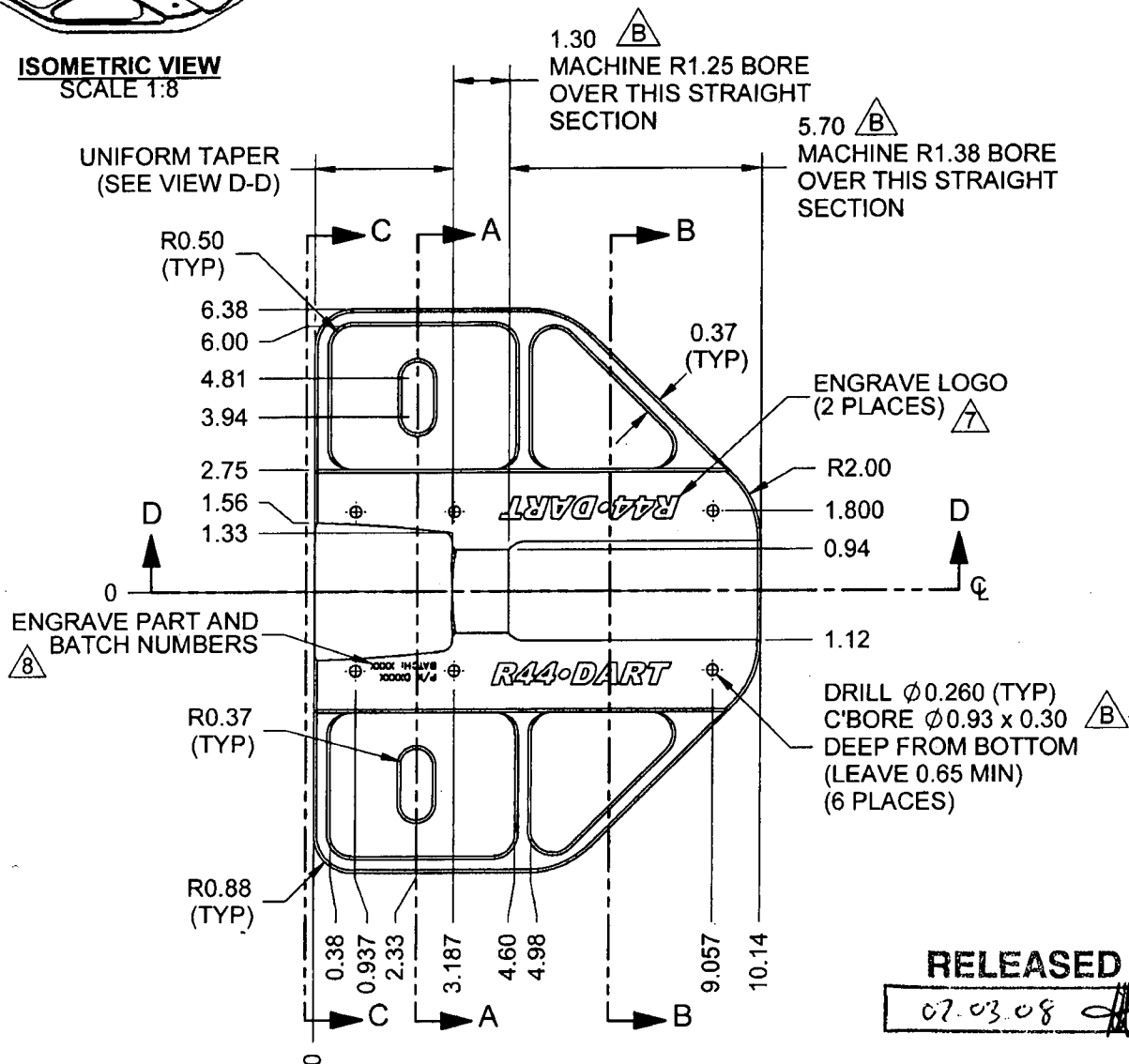
Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue	KJ/RF	J

DART

DESIGN #1	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #3	APPROVED #	DRAWING NO. D3075	REV. B SHEET 1 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$; ADD QTY(2) HOLES AT (0.937, ± 1.800)	



ISOMETRIC VIEW
SCALE 1:8

**D3075-1 BEARPAW****NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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WORK ORDER

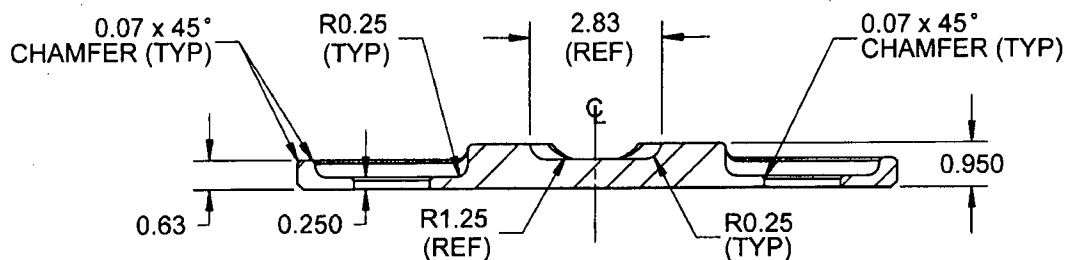
NO. 35348 A

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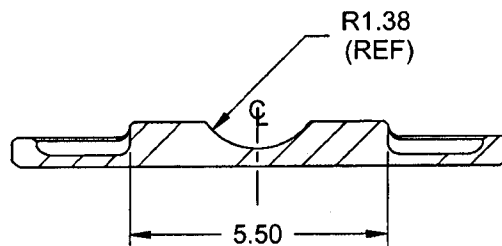
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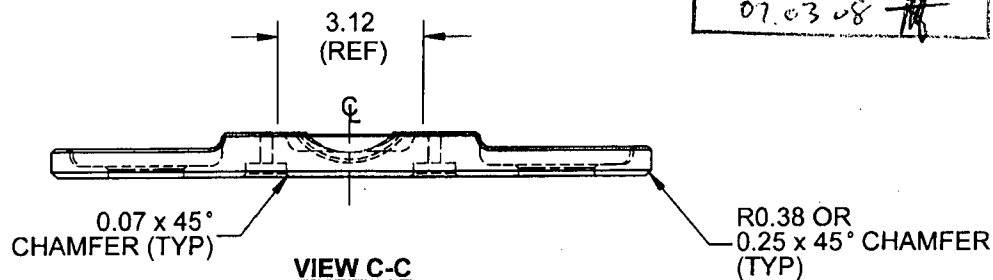
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CHECKED #3	APPROVED #	DRAWING NO. D3075	REV. B SHEET 2 OF 2
DATE 07.02.27		TITLE R44 BEARPAW	SCALE 1:4



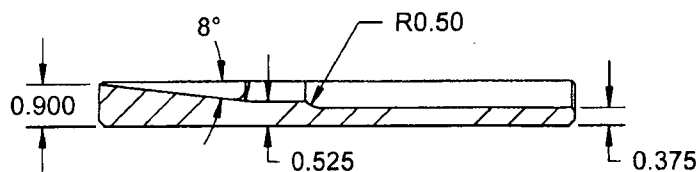
SECTION A-A



SECTION B-B



VIEW C-C



SECTION D-D

RELEASED

07.03.08

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